

Date: Friday, 11/17/2006 9:08:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP (CASTING DETAIL)
 Job Number : 29514
 Estimate Number : 11088
 P.O. Number : N/A Part Number : D25761
 This Issue : 11/17/2006 S.O. No. : N/A Drawing Number : D2576 REV E1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : E1
 Previous Run : N/A Material : N/A
 Due Date : 11/30/2006 Qty: 100 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 05-11-29 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2509
 Ship D2576 mould to vendor
 Cast per D2576-1 Pattern
 Material Release Note Required

c Loge 11/17

(100)

2.0 D25761P Step (Casting Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 STEP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure D2576 mould is returned with the ordered parts
 Ensure release note is attached

LB 06/11/27 (100)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

NA 06/11/30 (100)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 5777-6A

PU 4/12/00 (100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DA Date: 06/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:08:05 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 29514

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

06/12/04

Job Completion



06/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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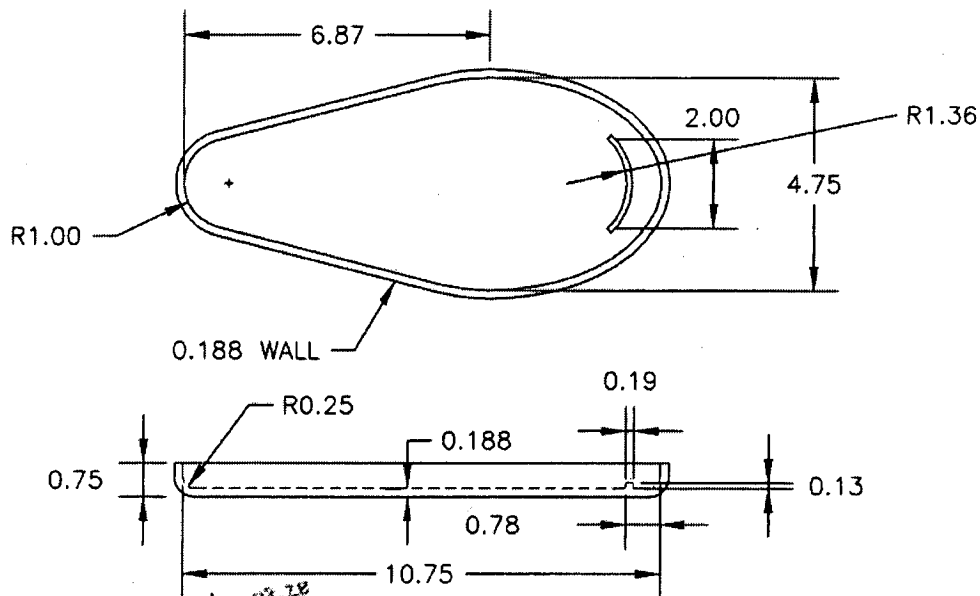


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	03.04.29	7.05 WAS 6.61	

RELEASED
99.09.08 DS

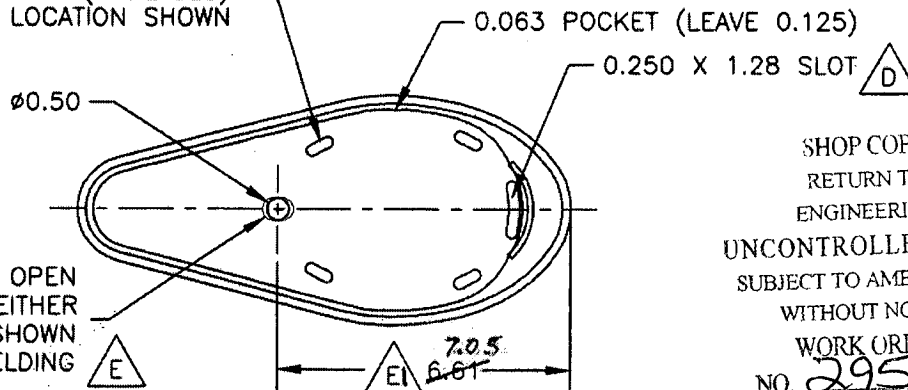
CASTING DETAIL (D2576-1) ^{#00.08.28}
_{03.08.28}

MATERIAL: CAST ALUMINUM ALLOY A-535.2
BREAK SHARP EDGES 0.025 TO 0.050
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) ^{#00.08.28}
_{03.08.28}

△ 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29514

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT
CANADA K6A 1K7**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via		Page
17-Nov-2006		PO0002509	29-Nov-2006	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship
1	✓ DART D2576	D2576 STEP CSTG		100		100
2						

DB
*06/11/27***Comments**

Castings & Patterns are property of Alpine until paid in full

Nov 24/06

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE

NOV 06 2006

CONFORMS TO ASTM SPECIFICATION: B179-03

Alloy: 535.2

Heat: G862

Si	0.044
Fe	0.074
Cu	0.001
Mn	0.131
Mg	6.770
Cr	0.001
Zn	0.003
Ti	0.167
Sn	0.003
Pb	0.001
Ni	0.001
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-.25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-.25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakrzewski

NOV 06 2006

RON ZAKRZEWSKI

DATE

LAB MANAGER

PM-12.01 Rev D 12/5/2001

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.